

**Work Order ID 71984**

Page 1

Friday, July 15, 2011 8:00:17 AM

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 7/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00



DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

8 blocks

HJ for BG 11-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 11/07/28

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: ☐ M16778 BE 11/17/12

12-Grind welds flush as per Dwg D2750 BE 11/17/12

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S u l o s l o z

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u l o s l o z

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>1</u>			<u>B 11/15/11</u>
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>1</u>	<u>0</u>		<u>BE 11/16/11</u>

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Customer:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Skidtubes	Skidtubes	0.00							
Skidtubes	<b>Memo</b> 1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. 3-Open float holes to .500" (4 per Side) 4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6-Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> Sikaflex-291 batch: <u>117566</u> exp. date: <u>12/01/15</u> 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: <u>m115778</u> 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per	0.00							

BE11/08/02

BE11/08/03

B 11/08/04

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Customer:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12-Deburr holes								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
 QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
 QC	Memo	0.00							
Quality Control									

11/08/04

Sulobor

Sulobor

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

IX Ø M-L 11/08/09

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30 AM  
OVEN TEMPERATURE: 326°F  
FINISH TIME: 8:00 AM

1 Ø M-L 11/08/10

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

IX Ø M-L 11/08/15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing					1	0	11108115	
HandFinish	Memo	0.00							
Hand Finishing	✓ Install inserts as per dwg D2750								
230		0.00							
	HandFinishing					1	0	11108115	
HandFinish	Memo	0.00							
Hand Finishing	✓ 1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3"								
	✓ batch: 101A								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	✓ SIKA FLEX 241								
	BATCH: 11117516								
	EXP DATE: 101								
	✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: 1111416								
	5-Coat all exposed fasteners with "LPS Procyon"								
	✓ batch: 11114596								

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	8 ulos/lis			(40)			
250  Packaging Packaging	Pick Kit  Memo	0.00  0.00							11 Ks/17.2
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00	8 ulos/lis			(40)			

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270  Packaging	Packaging	0.00							
	Memo	0.00							
	Package as per PPP D350-636-012								
280  QC	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							
	Quality Control								

11/2/13

11/8/19

11-08-19

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# Picklist Print

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Page 1

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07-13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as per  
 IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-225		Purchased	No			220	Each	268.0000	38	38			
Insert													

Location	Loc Qty	Loc Code
ST282	268	1111529
110768	209	
117717	59	

AN3C5A		Purchased	No			230	Each	1,183.000	34	34			
Bolt													

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1176	
116419	28	
116549	42	
117343	500	
117764	300	
117872	306	

# Dart Aerospace Ltd

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Start Date: 7/15/2011

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Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

172.0000

4

4



BOLT



Jul 11/08/15

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

171

111982

2

116419

23

116549

2

116704

12

117619

22

117688

60

117872

50

AN6C44A

Purchased

No

230

Each

61.0000

4

4



BOLT



Jul 11/08/15

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

59

117763

7

117950

50

118112

2

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Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

143.0000

1

1



BOLT



u 110815

## Location

## Loc Qty

## Loc Code

FP

106

117511

40

118286

66

FP-A

2

115960

1

116874

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38



washer

1118306



(x38) u 110815

AN960C816L

NAS1149C0832

Purchased

No

230

Each

0.0000

1

1



WASHER

1114915



(x1) u 110815

D2745

Manufactured

No

230

Each

228.0000

8

8



Bushing



u 110815

## Location

## Loc Qty

## Loc Code

FP-A

228

68248

1

69529

155

69816

72

x8

Friday, July 15, 2011 8:00:24 AM

Shop Packet Print

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 15, 2011 8:00:24 AM

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

24.0000

1

1



Blade Fitting Assembly, RH



Jul 11/08/15

Location

Loc Qty

Loc Code

FP008

24

62003

1

68109

11

60904

12

D3492-1

Manufactured No

230

Each

84.0000

8

8



Plug



Jul 11/08/15

Location

Loc Qty

Loc Code

FP

84

69531

8

69819

52

70689

24

371836

x2

D3492-3

Manufactured No

230

Each

84.0000

8

8



Plug



Jul 11/08/15

Location

Loc Qty

Loc Code

FP

84

69822

20

70692

64

x5

x3

D3535-25

Manufactured No

230

Each

29.0000

1

1



Wearshoe



Jul 11/08/15

Location

Loc Qty

Loc Code

FP018

29

62233

1

69284

3

69743

25

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 15, 2011 8:00:24 AM

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

32.0000

1

1



Gasket



Jul 11/08/15

Location

Loc Qty

Loc Code

FP012

32

68351

6

70780

26

X1

D3537-1

Manufactured No

230

Each

19.0000

3

3



Wearpad



Jul 11/08/15

Location

Loc Qty

Loc Code

FP017

19

69817

5

70686

14

X3

D3631-1

Manufactured No

230

Each

339.0000

8

8



Washer



Jul 11/08/15

Location

Loc Qty

Loc Code

ST072

339

68062

339

Y2

D3672-1

Manufactured No

230

Each

992.0000

8

8



Phenolic Washer



8

P70-2

Location

Loc Qty

Loc Code

ST074

990

64177

490

66821

500



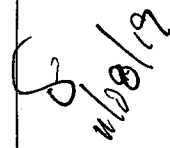
ST077

2

52505

2

**Dart Aerospace Ltd**

W/O: 71984		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/08/15	230	Assemble with NAS1515H36 / M113362 washer  Permanent change!	 	11/08/15 11-08-19	x4	N/A	 11/08/19

**Part No:** D350-636-012 **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 6

Friday, July 15, 2011 8:00:25 AM

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

9.0000

1

1



Wearplate



*u u10815*

Location

Loc Qty

Loc Code

FP017

9

1369282

62239

2

*x1*

69744

7

D3793-1

Manufactured No

230

Each

27.0000

1

1



Wearshoe



*u u10815*

Location

Loc Qty

Loc Code

FP018

27

69285

9

*x1*

70781

18

D3793-3

Manufactured No

230

Each

21.0000

1

1



Wearshoe



*u u10815*

Location

Loc Qty

Loc Code

FP018

21

68356

1

69283

8

*x1*

70813

12

D3794-1

Manufactured No

230

Each

31.0000

1

1



Gasket



*u u10815*

Location

Loc Qty

Loc Code

FP010

31

68355

7

70779

24

*x1*

Friday, July 15, 2011 8:00:25 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, July 15, 2011 8:00:25 AM

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

24.0000

1

1



Gasket



u108113

Location

Loc Qty

Loc Code

FP010

12

68357

12

x1

FP018

12

70812

12

MS21043-6

Purchased

No

230

Each

421.0000

4

4



NUT



u108115

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

401

112314

391

x4

117887

10

MS21083C8

Purchased

No

230

Each

79.0000

1

1



NUT



u108115

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

28

115884

0

117423

17

x1

117677

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 15, 2011 8:00:25 AM

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

150.0000

8

8



O-RING



44 4108115

Location

Loc Qty

Loc Code

FP

56

117460

8

118077

48

FP-A

94

110915

91

x 8

115589

3

NAS1611-013

Purchased

No

230

Each

128.0000

8

8



O-RING



44 4108115

Location

Loc Qty

Loc Code

FP

123

1118384

x 8

117291

2

117887

121

FP-A

5

116582

5

AN8C21A

Purchased

No

250

Each

89.0000

2

2



BOLT



44 4108115

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

64

117562

14

118045

50

AN960JD816

Purchased

No

250

Each

0.0000

2

2



1/2" washer, Alum



NAS114900863

44 4108115

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 9

Friday, July 15, 2011 8:00:26 AM

Work Order ID: 71984

Parent Item: D350-636-012


Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2741  
  
 Blade, 350 Skidtube

Manufactured No

250 Each 31.0000



1

*Handwritten signature*

Location

Loc Qty

Loc Code

ST466


31

63589

1

69133

30

D3493-1  
  
 Washer

Manufactured No

250 Each 71.0000



2

*Handwritten signature*

Location

Loc Qty

Loc Code

ST062


71

68253

11

70697

60

D3532-1  
  
 Spacer

Manufactured No

250 Each 39.0000



2

*Handwritten signature and date 11/21/17*

Location

Loc Qty

Loc Code

ST065

39

69895

39

*Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, July 15, 2011 8:00:26 AM

Page 10

Work Order ID: 71984  
 Parent Item: D350-636-012  
 Parent Item Name: Skidtube RH



Start Date: 7/15/2011  
 Start Qty: 1.00

Required Date: 7/29/2011  
 Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

79.0000

2

2



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

28

115884

0

117423

17

117677

11

D2600-3-BENT

Manufactured

No

110

Each

13.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

13

66875

8

70142

5

D2744

Manufactured

No

110

Each

37.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

37

62715

1

65086

4

70881

32

Friday, July 15, 2011 8:00:26 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, July 15, 2011 8:00:26 AM

Page 11

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

2.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

70823

2

69886

2

D2743

Manufactured No

160 Each

163.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

105

69818

105

LG001

58

67766

4

68251

54

D3490-3

Manufactured No

160 Each

77.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

77

68952

18

70768

59

Friday, July 15, 2011 8:00:27 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

Friday, July 15, 2011 8:00:27 AM

Work Order ID: 71984

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

97.0000

4

4



Cross Bolt Spacer

JE11/08/23

Location

Loc Qty

Loc Code

LG

95

67773

5

69510

30

69823

60

LG001

2

62450

2

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# **GENERAL NOTES:**

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 719821

*11-07-15*

**RELEASED**  
*08-07-15*

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3536-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS. CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PH</i>	D2750	SHEET 1 OF 11
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	350 SKIDTUBE ASSEMBLY	NTS
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

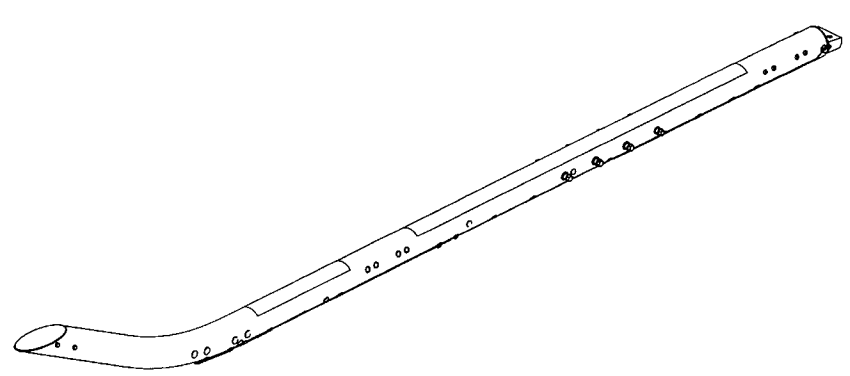
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

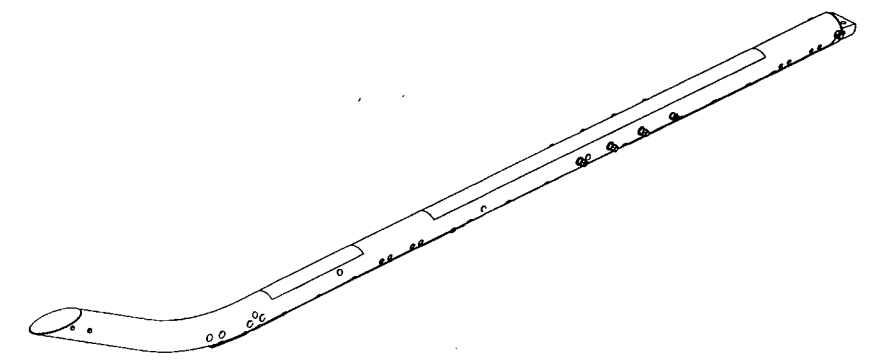
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

71984



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
08-09-22 AM

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	MY	<b>D2750</b>	SHEET 2 OF 11
APPROVED	MY	TITLE	SCALE
DE APPR.	MY	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

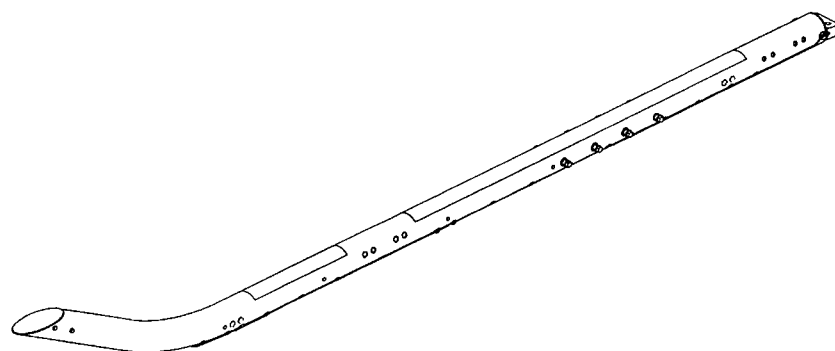
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

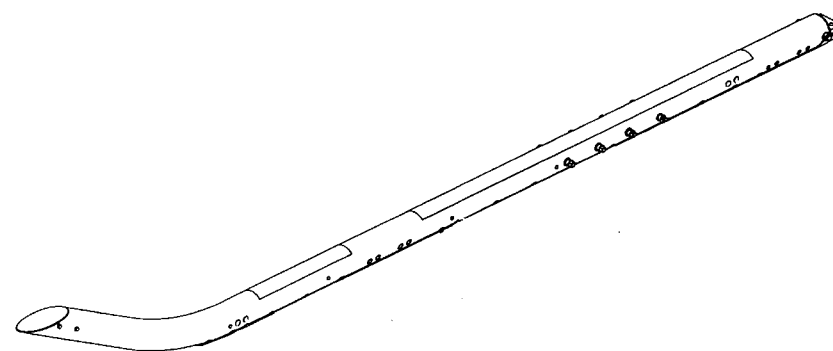
**NOTE:** Date & initial all entries



71984



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-9221-11

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

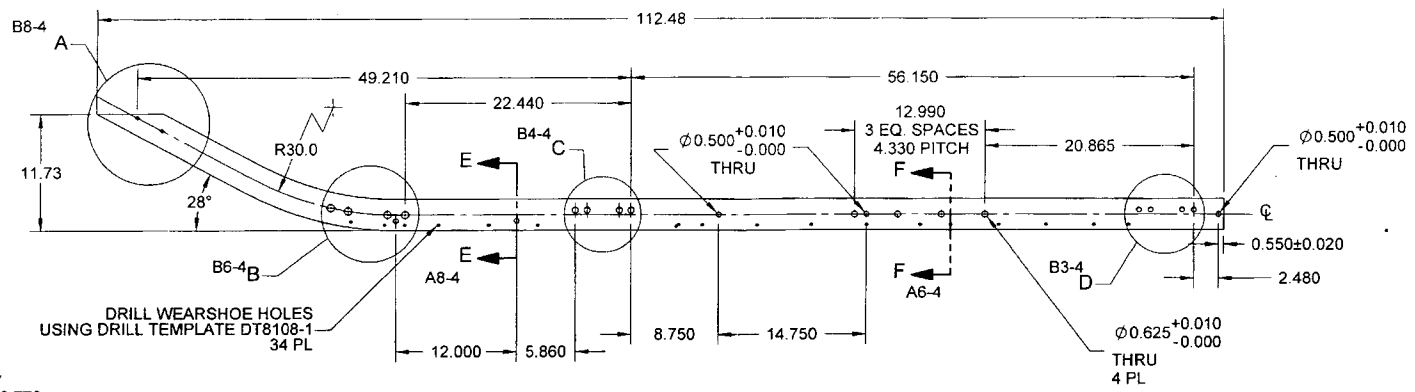
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

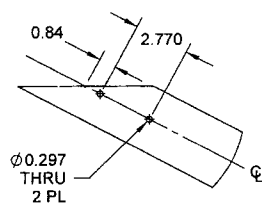
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

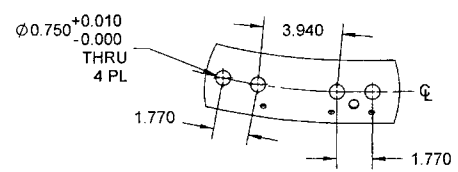
**NOTE:** Date & initial all entries



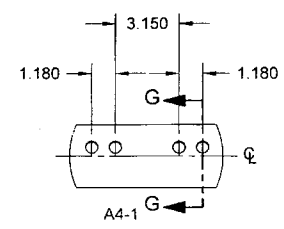
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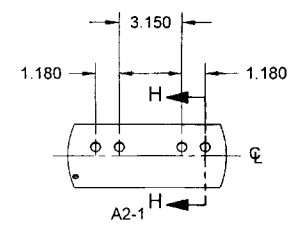
**DETAIL A**  
SCALE 2X



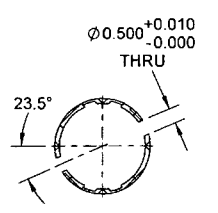
**DETAIL B**  
SCALE 2X



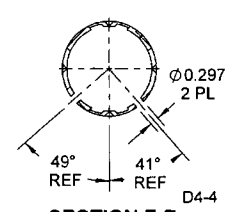
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SCALE 2X



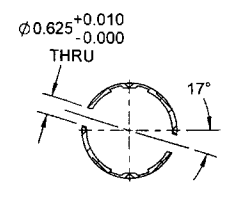
**DETAIL D**  
SCALE 2X



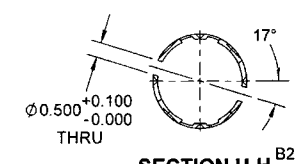
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**  
08-09-2017

DESIGN	JP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR		350 SKIDTUBE ASSEMBLY	NTS
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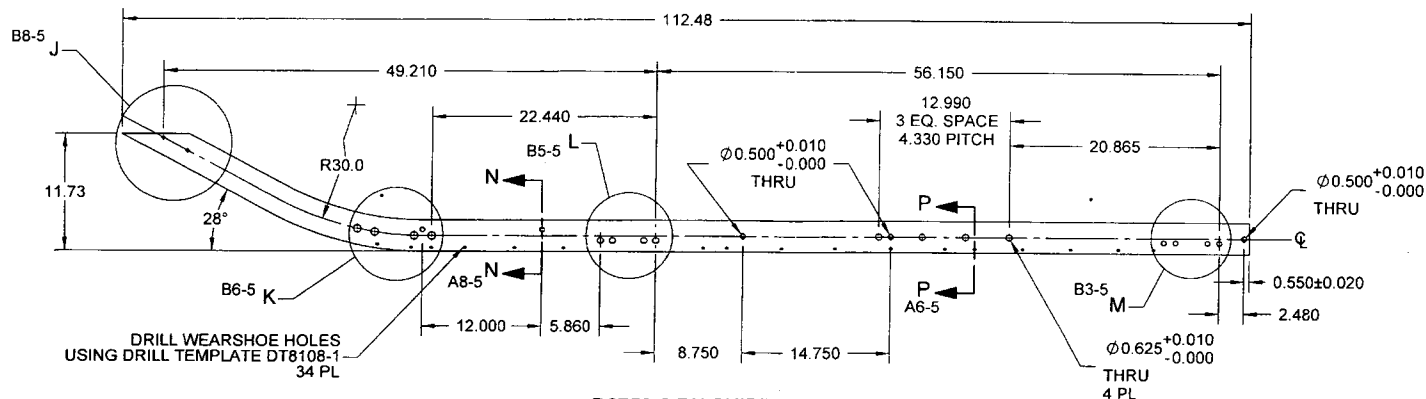
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

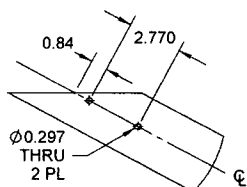
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

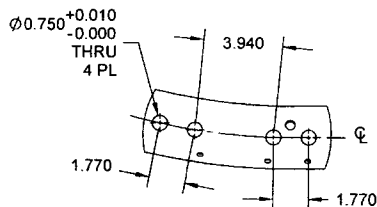
**NOTE:** Date & initial all entries



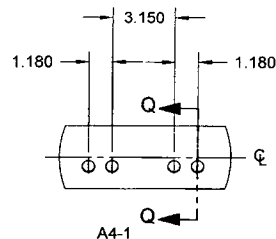
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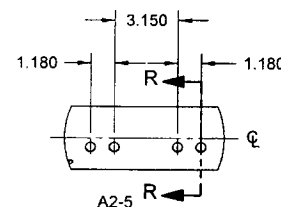
**DETAIL J**  
SCALE 2X



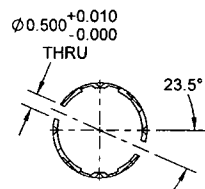
**DETAIL K**  
SCALE 2X



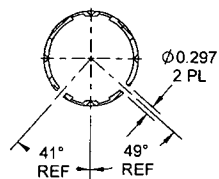
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SCALE 2X



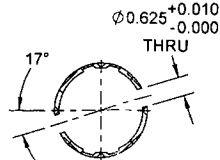
**DETAIL M**  
SCALE 2X



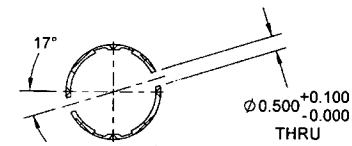
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		SHEET 5 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

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**Dart Aerospace Ltd**

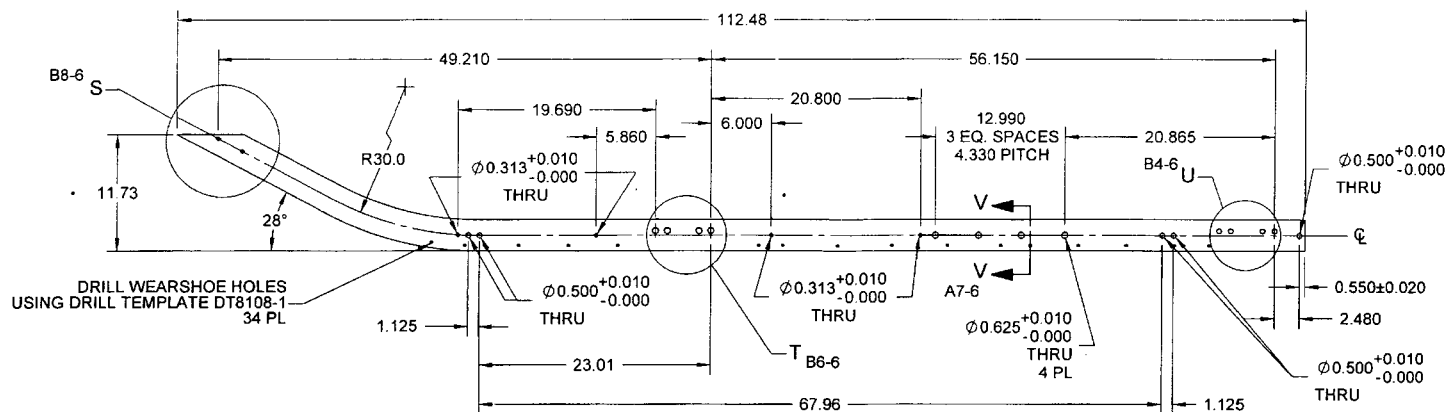
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

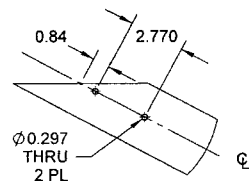
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

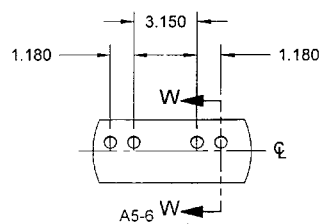
**NOTE:** Date & initial all entries



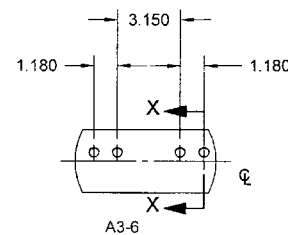
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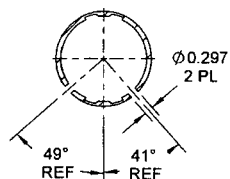
**DETAIL S**  
D8-6  
SCALE 2X



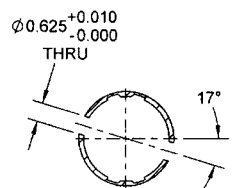
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C5-6  
SCALE 2X



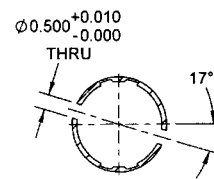
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

**RELEASED**

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

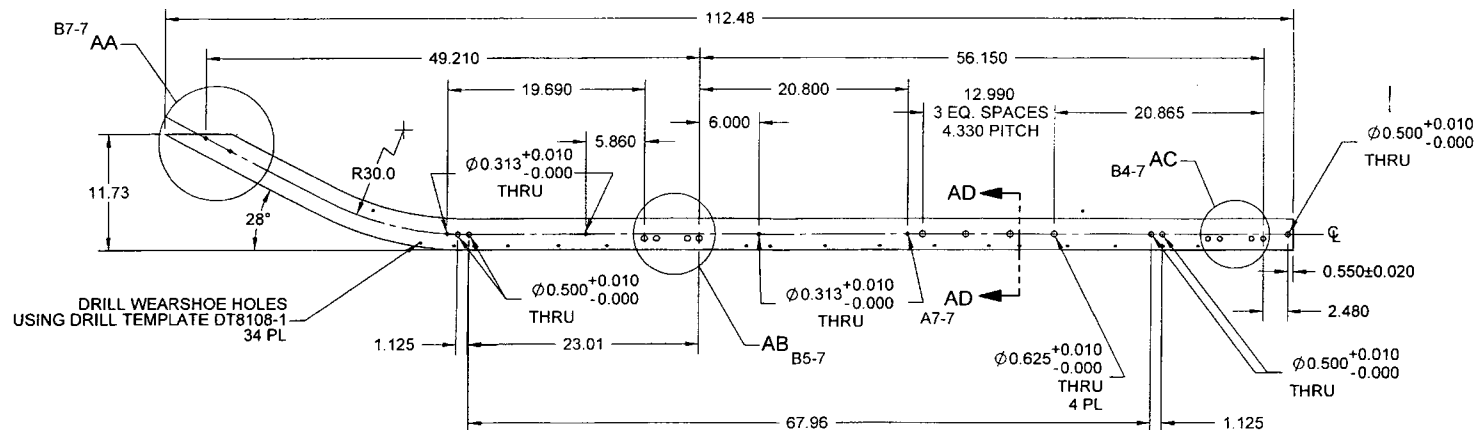
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

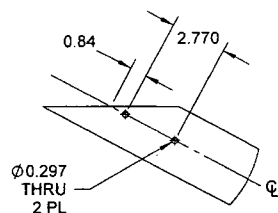
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

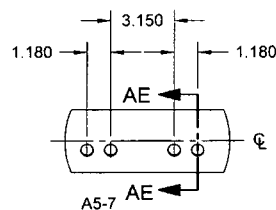




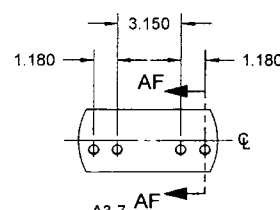
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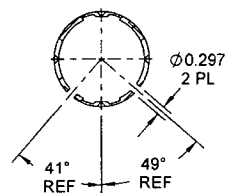
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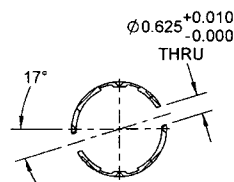
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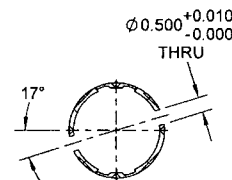
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

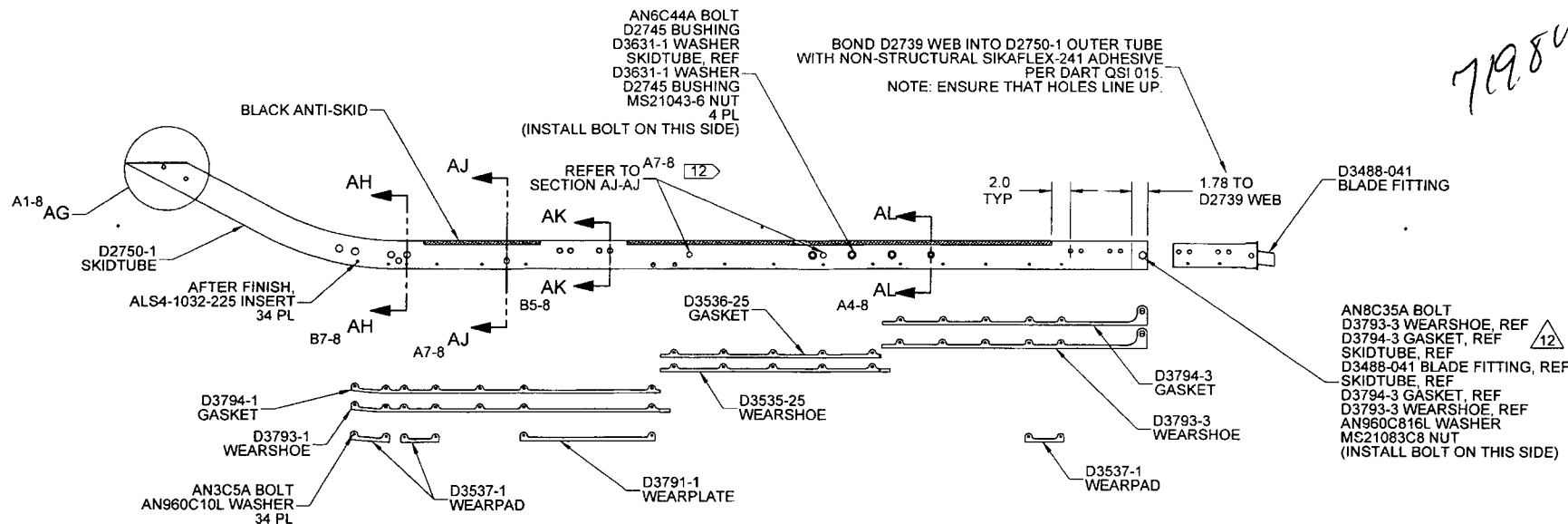
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

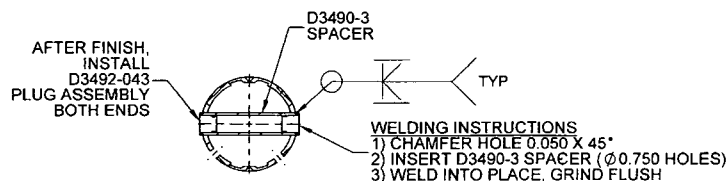
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

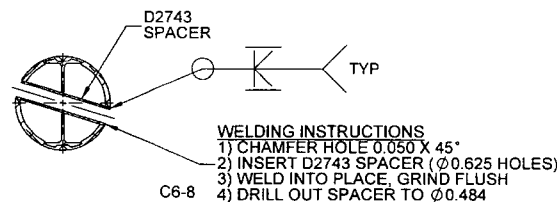
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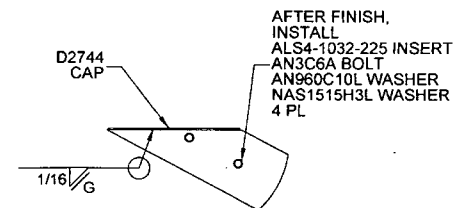
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



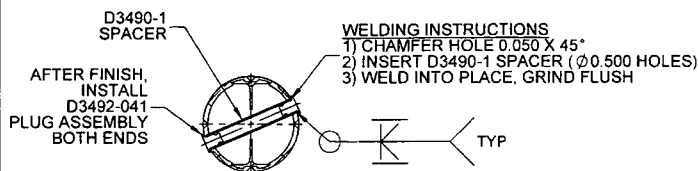
**SECTION AH-AH**  
SCALE 3X, 4 PL



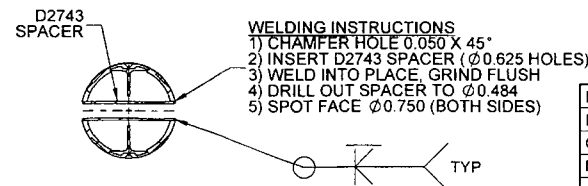
**SECTION AK-AK**  
SCALE 3X, 4 PL



**DETAIL AG**  
SCALE 2X



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**RELEASED**

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 8 OF 11
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
DE APPR.			
DATE	<b>08.07.16</b>		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

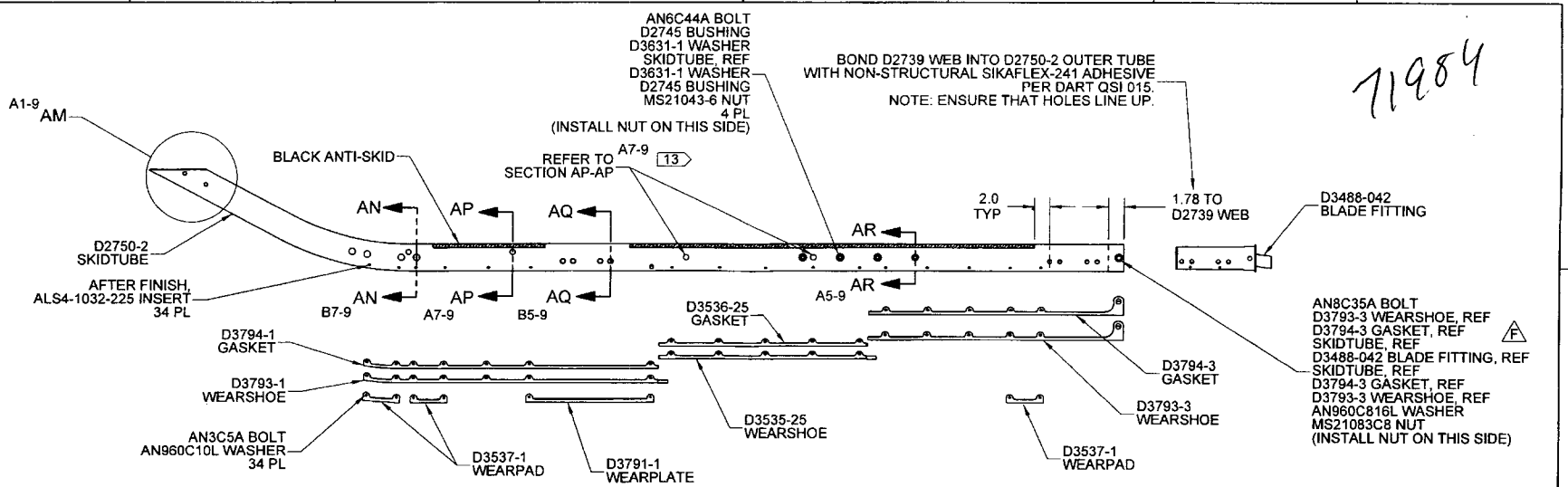
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

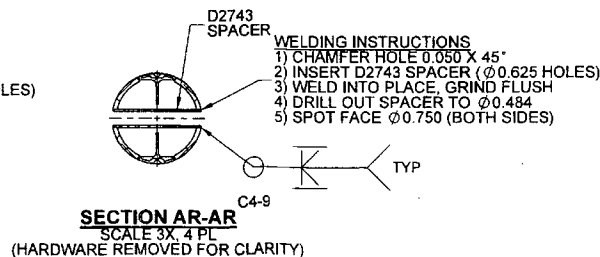
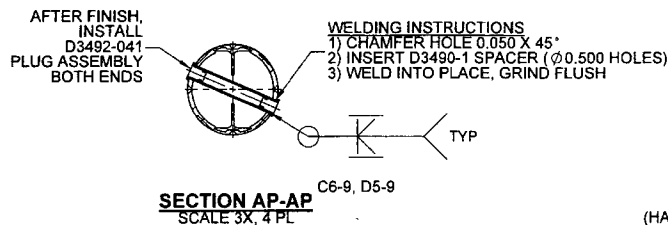
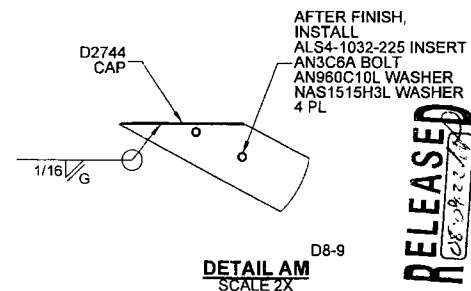
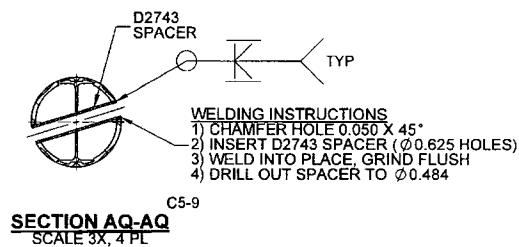
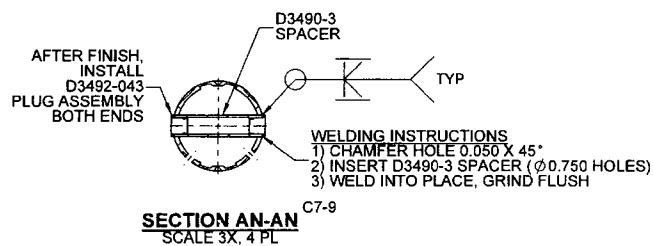
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

71984



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	<b>D2750</b>	SHEET 9 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2008-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

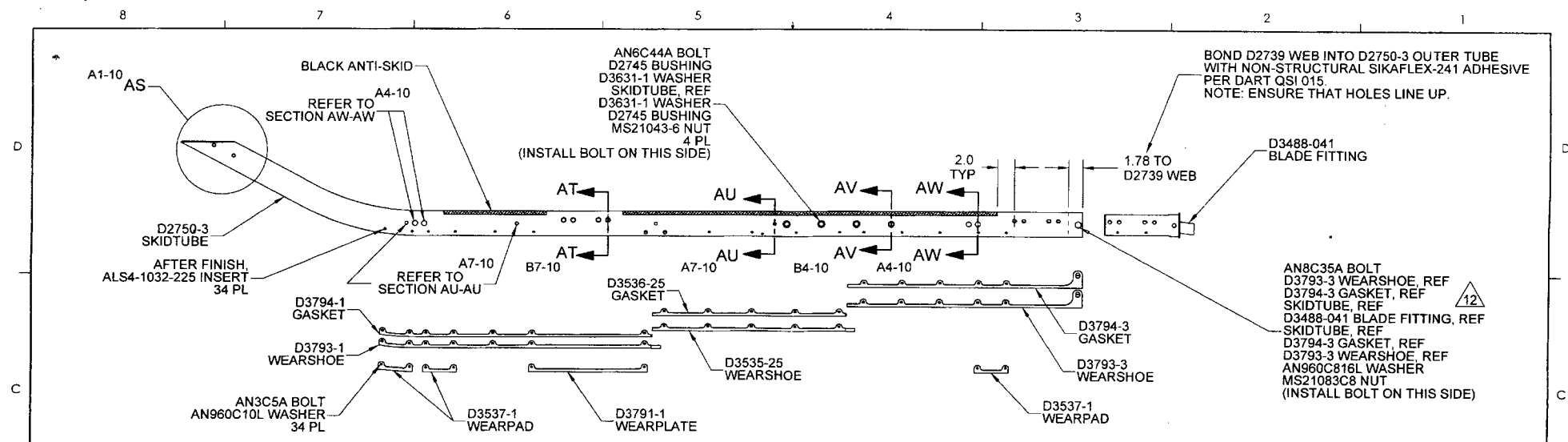
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

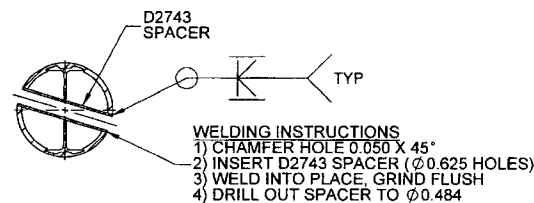
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

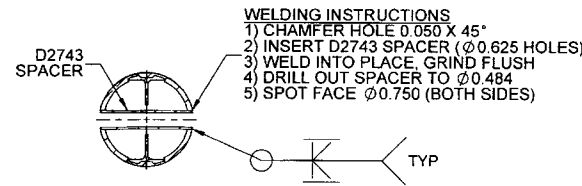
11984



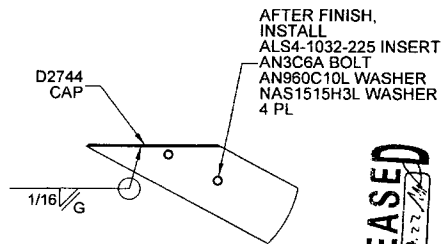
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



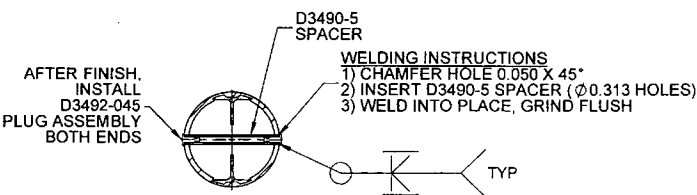
**SECTION AT-AT**  
SCALE 3X, 4 PL



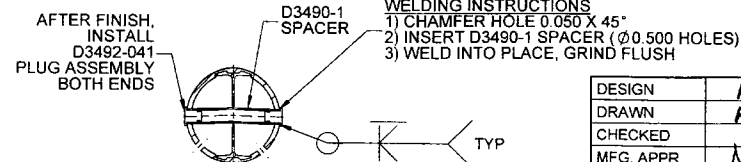
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AS**  
SCALE 2X



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL

DESIGN	11984	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	11984	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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11984

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

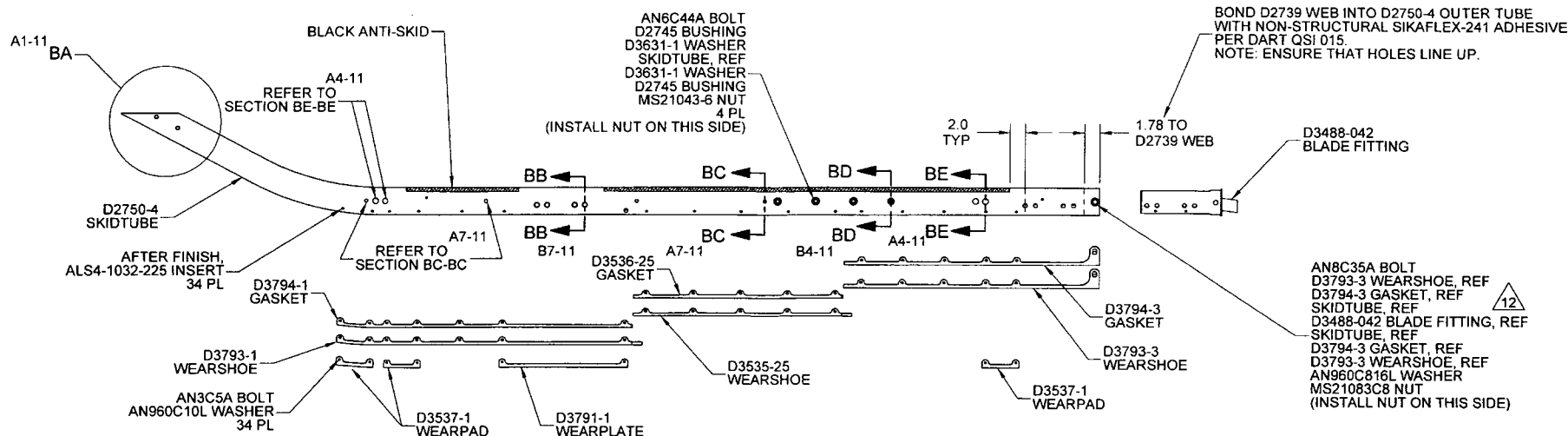
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

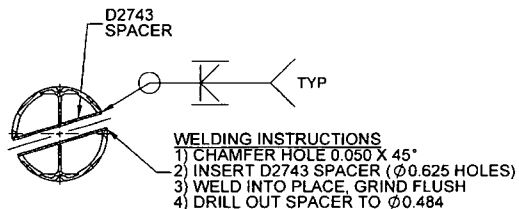
**NOTE:** Date & initial all entries



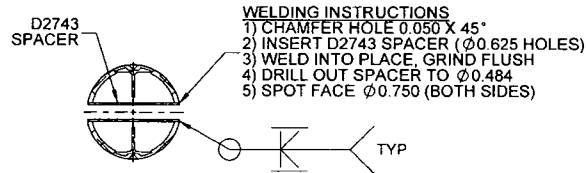
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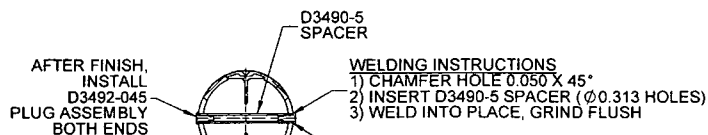
# **D2750-044 350 SKIDTUBE ASSEMBLY, RH**



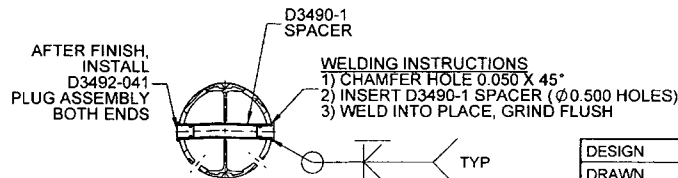
## **SECTION BB-BB** SCALE 3X, 4 PL



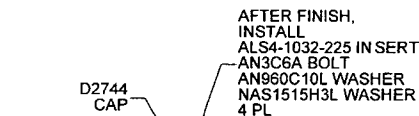
## **SECTION BD-BD** SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



## **SECTION BC-BC** SCALE 3X, 4 PL



## **SECTION BE-BE** SCALE 3X, 4 PL



## **DETAIL BA** SCALE 2X

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		SHEET 11 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	08.07.16	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 260

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B.69707  
Part number: D350-636-011  
Description: 350  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Dunn Date of Test Coupon 11-07-08  
Welder Barclay Elliott Date of Test Coupon 11-07-08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld